

shp Nov. 25th special part

Work Order ID 76335

76335

Page 1

November-09-11 10:06:46 AM

Item ID: D350-636-018

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: M.C.J. Date: 11/11/09 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4168

A

IIN-D350-636

I

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-018 CHG 002

21 11 91' 30 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335

76335

Page 2

November-09-11 10:06:46 AM

Item ID: D350-636-018

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill fwd step holes using DT9616 detail AA . Ensure proper positioning.								
	6- Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side section BE-BE and BC-BC								
	7- Clecko DT8864B on second side of tube and drill pilot holes for section BE-BE and BC-BC ***SECOND SIDE***								
	8-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.								
	9-Open up holes of Detail A to 0.297" (total of 2 holes per side) +.201" holes Detail AA.								
	10-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004								
	A/R Aluminum Rod batch: m118 735								

BE 11-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335***76335***

Page 3

November-09-11 10:06:46 AM

Item ID: D350-636-018

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Grind welds flush as per Dwg D4168

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November-09-11 10:06:46 AM

76335

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 09/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 14/11/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

0.00

HandFinish

Memo

Hand Finishing

150 QC3- Inspect Part Finish

0.00

150

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335***76335***

Page 5

November-09-11 10:06:46 AM

Item ID: D350-636-018

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.

2-Open up holes of wearplate holes to 0.375" section CK-CK (total of 4 holes per side) 0.3125" holes section BC-BC (4 per side) as per dwg D4168.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes dwg D4168 (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 49399

exp. date: 12/18/13

8- Weld spacers as per dwg D4168 & QSI004

(welding instructions on sheet 11)

A/R Aluminum Rod

batch: M118735

9- Grind welds flush as per Dwg D4168

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168

DL 11/11/18

DL 11/11/18

DL 11/11/19

DL 11/11/21

BB 11/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335

76335

Page 6

November-09-11 10:06:46 AM

Item ID: D350-636-018 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube w/ Training Wearplates, RH
 Start Date: 09/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11- C'bore section CK-CK					<i>B</i>	<i>11/11/21</i>		
	12- Deburr holes								
	***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****								
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		<i>11.11.24</i>		<i>1</i>	<i>Ø</i>		
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Sulur</i>		<i>70</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335

76335

Page 7

November-09-11 10:06:46 AM

Item ID: D350-636-018

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00				<u>11</u>	<u>11</u>	<u>11</u>	<u>24</u> (1)
200 *200* Powdercoat Powder Coating	White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							<u>11.11.26</u> (1)
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00							<u>124</u> of <u>11/11/25</u>

See attached - mark inside of tube
"ERA scheme" 11.11.26 (1)

11/18/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng' / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ERA
Sherwin Williams CM0483928
Polyurethane with Anti Mar Teflon additive CM0143603GA
CM0571080GA

11.11.26

AAI
Anodize
Alodine
PR-148 adhesion promoter (for anodize)
50/50 mix - Super Koropon and EC2216
Imron 555X

Apical
IAW MIL-P-23377J, TYPE 1 CLASS N &
Epoxy paint Cardinal 7125-E10192

Work Order ID 76335

76335

Page 8

November-09-11 10:06:46 AM

Item ID: D350-636-018 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube w/ Training Wearplates, RH
 Start Date: 09/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing					IRH	0	24	11/11/28
HandFinish	Memo	0.00							
Hand Finishing	✓ 1- Install inserts as per Dwg D2750								
230		0.00							
230	HandFinishing					IRH	0	24	11/11/28
HandFinish	Memo	0.00							
Hand Finishing	✓ 1-Inspect for Foreign Objects								
	✓ 2-Spray inside of tube with "LPS-3" batch: <u>NIA</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	✓ SIKA FLEX 241								
	BATCH: <u>11119445</u>								
	EXP DATE: <u>12/01</u>								
	✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube								
	A/R 55-o-ring lube batch: <u>11110348</u>								
	✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11114596</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335***76335***

Page 9

November-09-11 10:06:46 AM

Item ID: D350-636-018

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

1

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00					11	11	28 (1)
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00					11	11	30 (1)
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76335

76335

Page 10

November-09-11 10:06:46 AM

Item ID: D350-636-018 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube w/ Training Wearplates, RH
 Start Date: 09/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-018								
	Location: <i>Ship</i>								
	PPP rev: <i>Draft</i>								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

PP 76335

11/11/09

11/12/11

CLULU130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Page 1

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC
NCR 11-906 DD verf:EC

IPP Rev:B
IPP Rev:C 11.10.18 as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3490-1		Manufactured	No			160	Each	74.0000	4	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

8

67773

5

71841

3

LG001

66

62450

2

74875

64

Purchased

No

230

Each

63.0000

1

1

**

AN3C34A

AN3C34A

BOLT

Location

Loc Qty

Loc Code

ST353

63

116075

40

117514

20

118838

3

BE11-11-19
B76233 *4

11/11/2011

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased

No

230

Each

204.0000

4

4

AN3C36A

BOLT

**

Handwritten: 11/11/28

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

ST303

24

118757

24

Handwritten: x4

ST353

166

116590

0

119083

2

119125

4

119324

100

119530

60

AN3C37A

Purchased

No

230

Each

182.0000

1

Handwritten: 1

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

182

116874

11

117010

2

118518

44

118709

50

119324

25

119531

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C42A

Purchased No

230 Each 38.0000

1 1

AN3C42A

BOLT

**

11/18/11

Location

Loc Qty

Loc Code

ST354

38

106176

1

117763

17

118131

20

D3488-042

Manufactured No

230 Each 13.0000

1 1

D3488-042

Blade Fitting Assembly, RH

**

11/11/11

Location

Loc Qty

Loc Code

FP008

13

62003

1

69904

2

71883

10

D3490-5

Manufactured No

230 Each 36.0000

4 4

D3490-5

Cross Bolt Spacer

**

11/11/11

Location

Loc Qty

Loc Code

LG001

36

59230

36

D3492-1

Manufactured No

230 Each 70.0000

8 8

D3492-1

Plug

**

11/11/11

Location

Loc Qty

Loc Code

FP

70

69531

8

74444

62

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-5

Manufactured No

230

Each

24.0000

8

8

D3492-5

**

MU 11/11/2011

Plug

LocationLoc QtyLoc Code

FP

24

70698

24

x8

D3873-1

Manufactured No

230

Each

1,031.000

7

7

D3873-1

**

MU 11/11/2011

Bushing

LocationLoc QtyLoc Code

ST088

1031

64760

1

68247

4

73829

19

73830

207

73832

400

75481

400

x7

D4154-041

Manufactured No

230

Each

1.0000

1

1

D4154-041

**

B74074 (x1) MU 11/11/2011

Wearplate Assembly

LocationLoc QtyLoc Code

FP

1

71442

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4170-1 Manufactured No

230 Each 36.0000 4 4

D4170-1

Bushing

**

BB11-11-17

Location

Loc Qty

Loc Code

LG

32

68225

1

71844

31

LG002

4

65912

4

4

D4171-1 Manufactured No

230 Each 7.0000 1 1

D4171-1

Bushing

**

11/11/28

Location

Loc Qty

Loc Code

ST135

7

69037

7

MS21043-3 Purchased No

230 Each 727.0000 5

MS21043-3

Nut

**

11/11/28

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

655

118077

1

118614

477

118686

177

x 4

NAS1149C0363R Purchased No

230 Each 3,899.000 9

NAS1149C0363R

Washer

**

11/11/28

Location

Loc Qty

Loc Code

ST297

3899

114742

3899

x 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

171.0000

4

4

***NAS1515H3I ***

WASHER

**

~~M48384~~ (x1) M4 11/11/25

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

131

113362

27

118686

4

119438

100

NAS1611-005

Purchased

No

230

Each

236.0000

8

NAS1611-005

O-RING

**

89
M48384 11/11/25

Location

Loc Qty

Loc Code

FP002

136

106099

31

114220

105

FP-A

100

119438

100

NAS1611-010

Purchased

No

230

Each

217.0000

8

NAS1611-010

O-RING

**

89
M48384 11/11/25

Location

Loc Qty

Loc Code

FP

196

117460

8

118077

1

118612

3

119438

184

FP-A

21

110915

14

119307

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

214.0000

2

2

NAS1149D0863.J

WASHER

**

Handwritten: 24/11/25

Location

Loc Qty

Loc Code

ST298

214

118078

114

119307

100

Handwritten: x2

D2744

Manufactured

No

110

Each

55.0000

1

1

D2744

Cap

**

Handwritten: 09-11-16

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

42

71861

42

Handwritten: 1

D2600-3-BENT

Manufactured

No

110

Each

32.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Handwritten: DD 11-11-16

Location

Loc Qty

Loc Code

LG

32

66875

8

73253

1

75021

9

75022

10

75023

4

Handwritten: (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No

160 Each 135.0000 8 8

D2743

Crossbolt Spacer

**

BB11-11-79

Location Loc Qty Loc Code

LG	77	
71839	13	
73403	64	
LG001	58	
67766	4	
68251	54	

8

D2739 Manufactured No

160 Each 5.0000 1 1

D2739

350 I Beam

**

⑤

DL 11/11/8

Location Loc Qty Loc Code

LG	5	
72155	1	
72157	2	
75037	2	

76148

ALS4-1032-225 Purchased No

230 Each 2,302.000 4 4

AI S4-1032-225

Insert

**

rel

11/11/28

Location Loc Qty Loc Code

ST281	2302	
108696	422	
110768	62	
118386	858	
118966	960	

Y4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A Purchased No

230 Each 103.0000 1 1

AN8C35A

BOLT

**

Handwritten: 11/11/25

Location Loc Qty Loc Code

FP	67	
117511	1	
118286	66	
FP-A	1	
115960	1	
ST345	34	
<u>117834</u>	34	
ST346	1	X1
114442	0	
115188	0	
115960	1	

AN6C44A Purchased No

230 Each 123.0000 4 4

AN6C44A

BOLT

**

Handwritten: 11/11/25

Location Loc Qty Loc Code

FG	2	
103964	2	
ST343	121	
118387	1	
118985	40	
119125	30	
<u>119530</u>	50	X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Page 10

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

87.0000

1

1

MS21083C8

NUT

**

Handwritten signature and date 11/11/2011

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

85

115884

0

118614

41

119309

19

119436

25

Handwritten 'X' mark

D3631-1

Manufactured

No

230

Each

527.0000

8

8

D3631-1

Washer

**

Handwritten signature and date 11/11/2011

Location

Loc Qty

Loc Code

ST072

527

68062

27

75548

500

Handwritten 'X' mark

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

4

4

***AN960C10L ***

washer

**

Handwritten signature and date 11/11/2011



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

165.0000

8

D2745

Bushing

**

8
11/11/25LocationLoc QtyLoc Code

FP-A

81

69529

1

74446

80

ST021

84

71835

84

88

NAS1149C0832R

Purchased

No

230

Each

335.0000

1

NAS1149C0832R

WASHER

**

1
11/11/25LocationLoc QtyLoc Code

FP-B

7

114915

7

ST297

328

114915

328

81

November-09-11 10:06:51 AM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

268.0000

4

4

AN3C6A

BOLT

JL 11/11/25

LocationLoc QtyLoc Code

FP-A

1

111982

1

ST350

100

119449

100

ST351

167

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

112

X4

MS21043-6

Purchased

No

230

Each

465.0000

4

4

MS21043-6

NUT

JL 11/11/25

LocationLoc QtyLoc Code

FG

20

103693

20

ST300

445

112314

235

117887

10

118384

200

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

November-09-11 10:06:51 AM

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

39.0000

2

2

D3493-1

Washer

**

LocationLoc QtyLoc Code

ST062

39

70697

4

71846

35

MS21083C8

Purchased

No

250

Each

87.0000

2

2

MS21083C8

NUT

**

LocationLoc QtyLoc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

85

115884

0

118614

41

119309

19

119436

25

AN8C21A

Purchased

No

250

Each

79.0000

2

2

AN8C21A

BOLT

**

LocationLoc QtyLoc Code

ST343

79

118045

11

118758

38

119530

30

November-09-11 10:06:52 AM

Shop Packet Print

Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-09-11 10:06:52 AM

Page 14

Work Order ID: 76335

76335

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube w/ Training Wearplates, RH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

10.0000

1

1

D2741

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

10

70667

10

1 ~~10~~ 11/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C8A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76335 M.L.J
11/11/09

RELEASED
2010-09-15

A	NEW ISSUE	DESCRIPTION	SC	10.08.09
REV.			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4168	SHEET 1 OF 11	
APPROVED		TITLE	SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS	
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

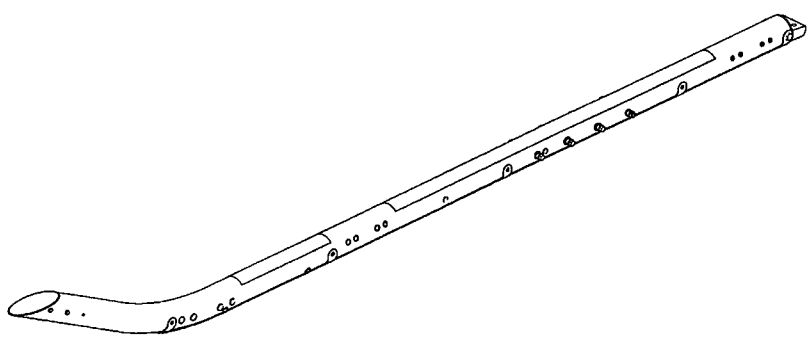
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

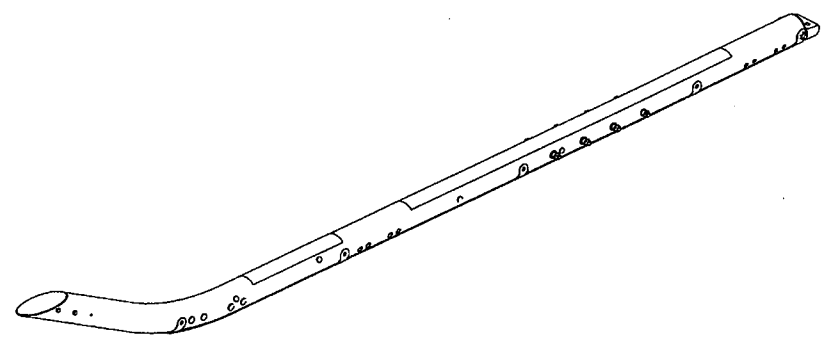
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76335



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2010-09-15
JW

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	SC	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4168 REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

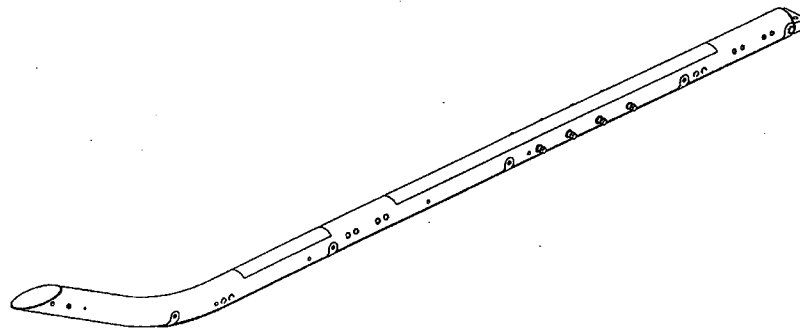
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

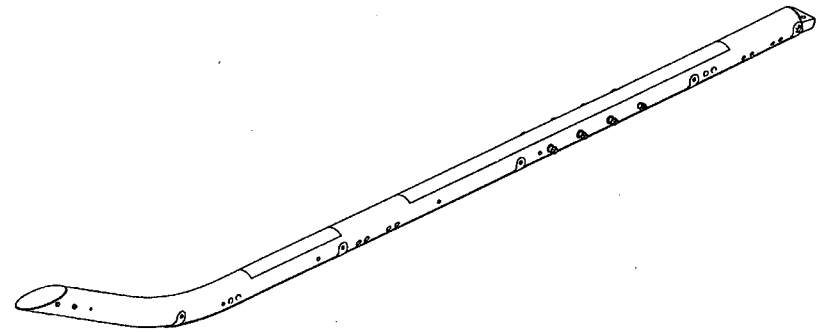
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76335



D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

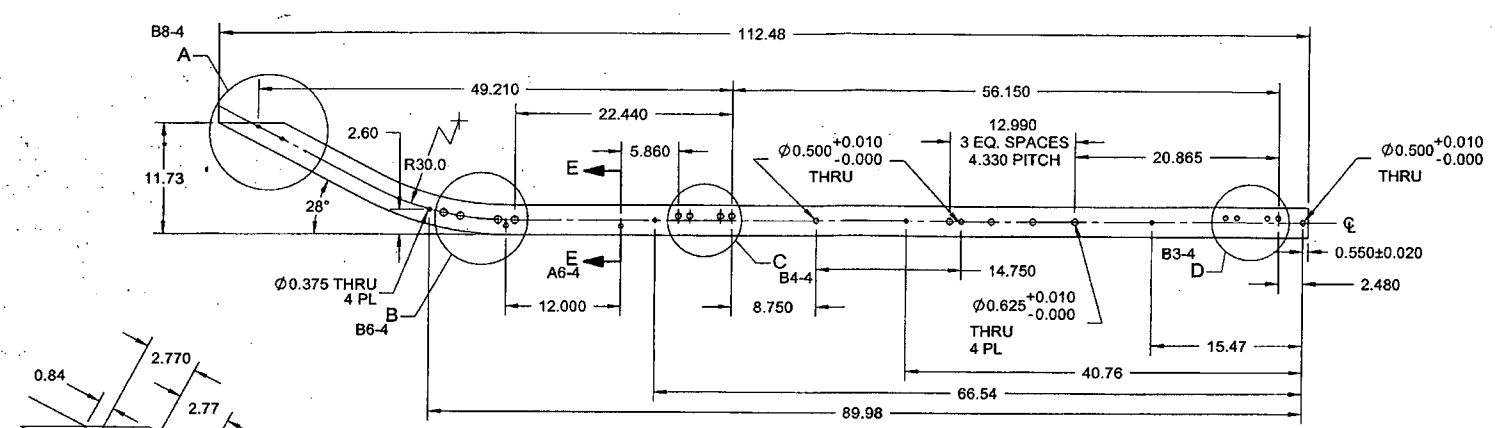
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

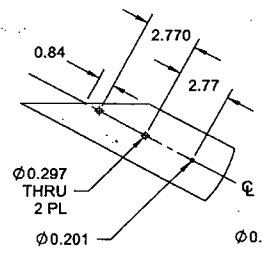
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

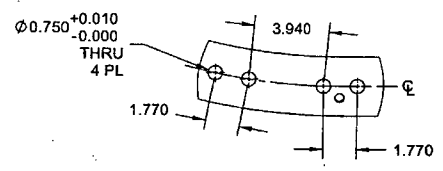
76335



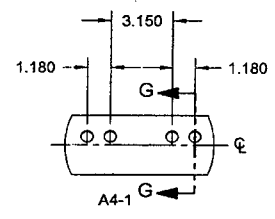
D4168-1 LH SKIDTUBE



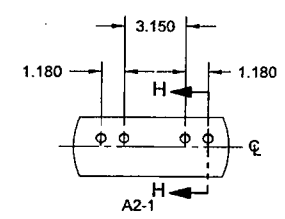
DETAIL A
SCALE 2X



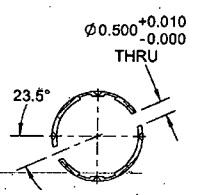
DETAIL B
SCALE 2X



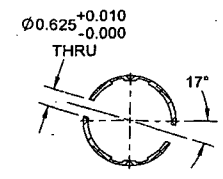
DETAIL C
SCALE 2X



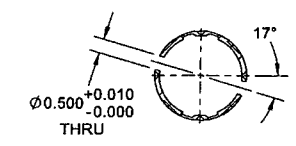
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

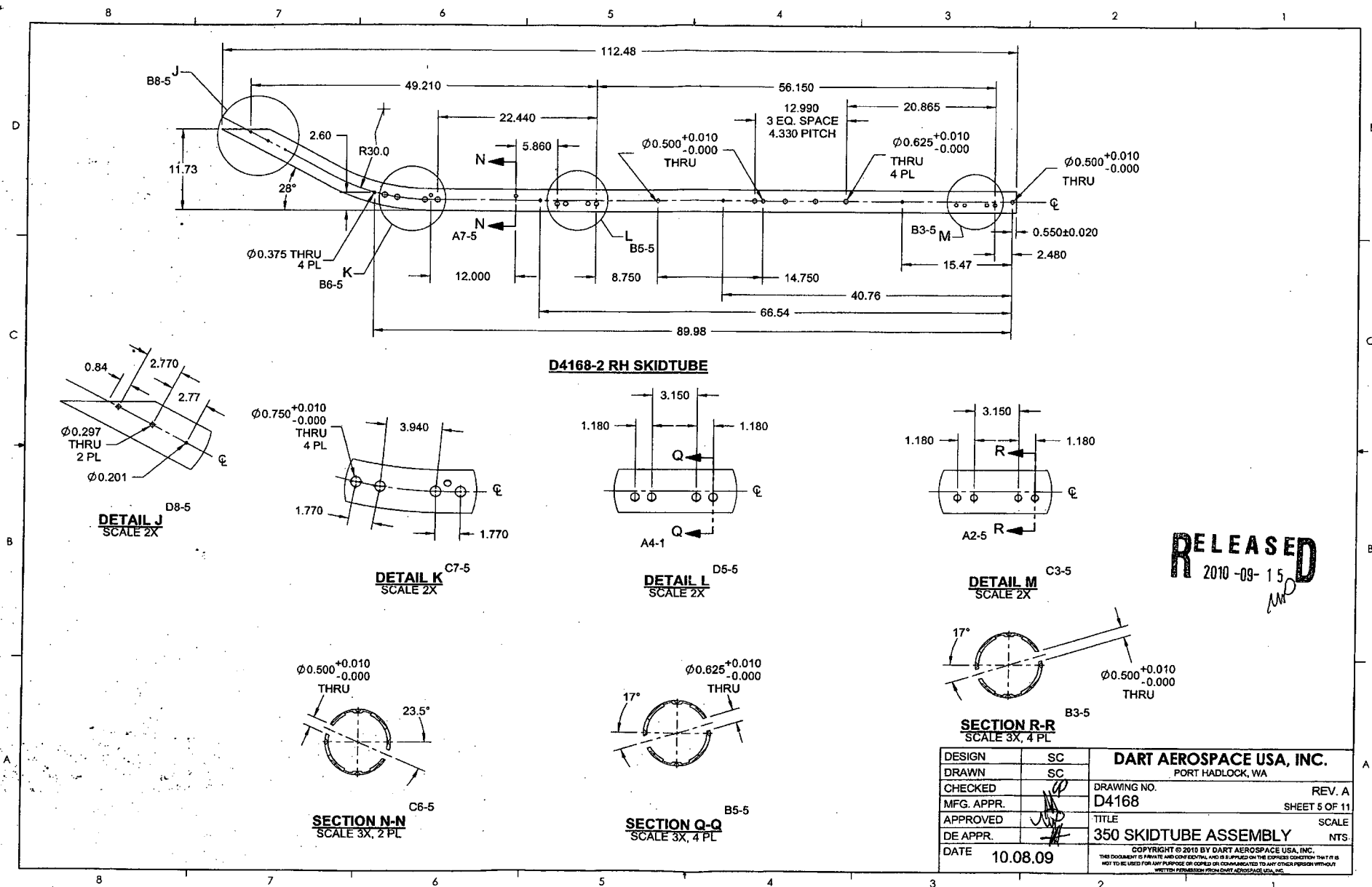
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76335



RELEASED
2010-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

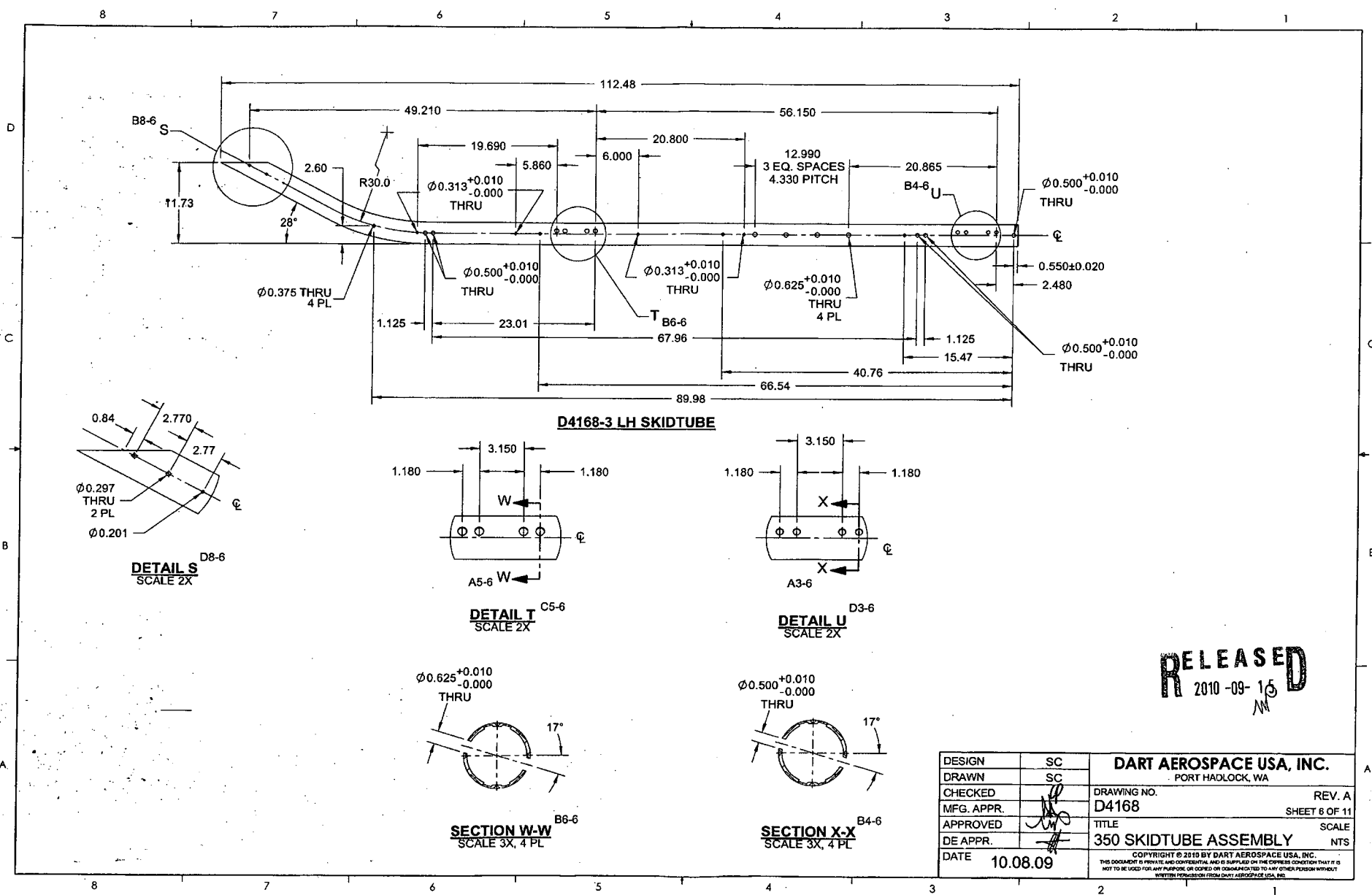
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76335



RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

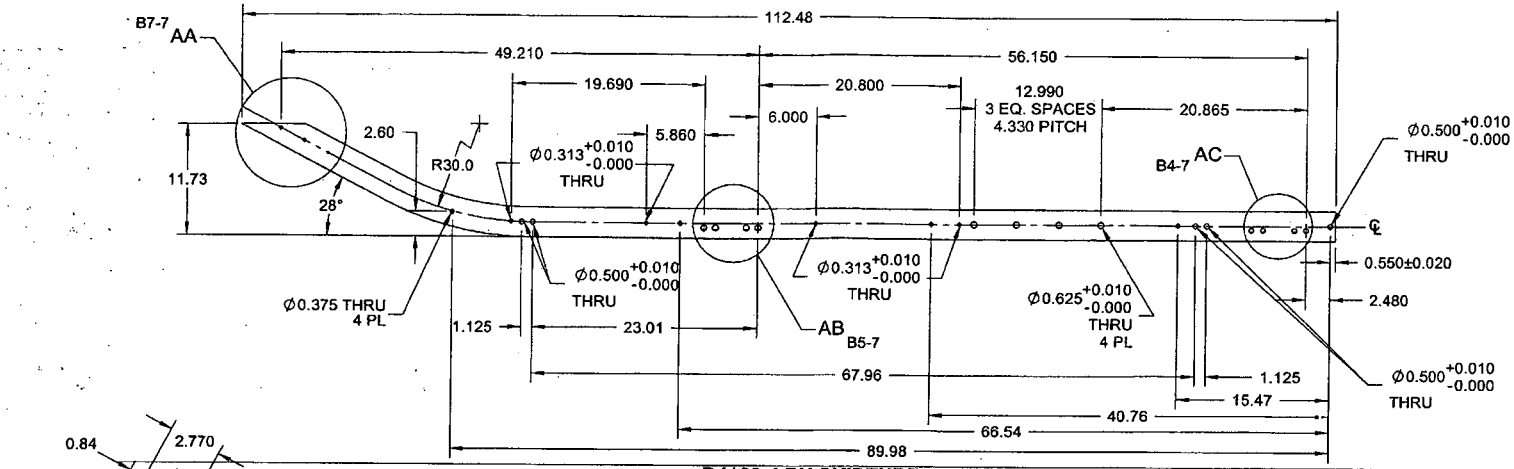
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

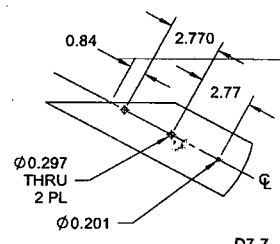
NOTE: Date & initial all entries

76335

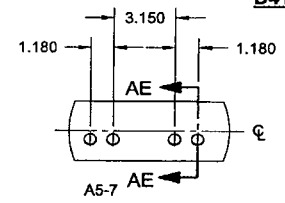
8 7 6 5 4 3 2 1



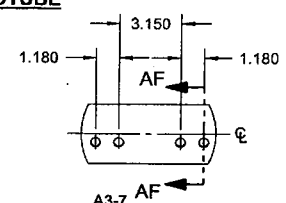
D4168-4 RH SKIDTUBE



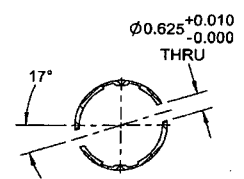
DETAIL AA
SCALE 2X
D7-7



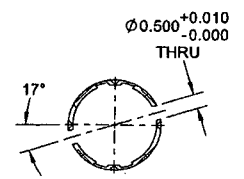
DETAIL AB
SCALE 2X
C4-7



DETAIL AC
SCALE 2X
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7



SECTION AF-AF
SCALE 3X, 4 PL
B4-7

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4168	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

AN6C44A BOLT, N.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL BOLT ON NEAR SIDE)

BOND D2739 WEB INTO D2750-1 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

BLACK ANTI-SKID

A1-8 AG

AN3C34A BOLT, N.S.
AN960C10 WASHER, 2X
MS21043-3 NUT

D4168-1 SKIDTUBE

AH

AJ

REFER TO SECTION AJ-AJ

A7-8

AK

AL

2.0 TYP

CG

1.78 TO D2739 WEB

D3488-041 BLADE FITTING

AN8C35A BOLT, N.S.
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D4154-041 WEARPLATE ASSEMBLY, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON NEAR SIDE)

B7-8 AH

A7-8 AJ

B5-8

AK

A4-8

CG

B3-8

AN3C36A BOLT, N.S.
AN960C10 WASHER, 2X
D3873-1 BUSHING, 2X
MS21043-3 NUT
3 PL

AN3C36A BOLT, N.S.
D4171-1 BUSHING
D3873-1 BUSHING
AN960C10 WASHER
MS21043-3 NUT
1 PL

D4154-041 WEARPLATE ASSEMBLY

D4168-041 350 SKIDTUBE ASSEMBLY, LH

D4170-1 SPACER

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1) CHAMFER HOLE 0.030 X 45°
2) INSERT D4170-1 SPACER
3) WELD INTO PLACE AND GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.313 X 0.500^{+0.06}_{-0.00} DEEP

TYP

C3-8

SECTION CG-CG
SCALE 3X, 4 PL

D2743 SPACER

C6-8

SECTION AK-AK
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

D2744 CAP

1/16" G

AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

C7-8

SECTION AH-AH
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

D3490-1 SPACER

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

C6-8, D5-8

SECTION AJ-AJ
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)

D2743 SPACER

C4-8

SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DETAIL AG
SCALE 2X

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4168	SHEET 8 OF 11
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2010-09-15

RELEASED
2010-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D4168-043 350 SKIDTUBE ASSEMBLY, LH

SECTION AT-AT
SCALE 3X, 4 PL

SECTION AU-AU
SCALE 3X, 4 PL

SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

SECTION AW-AW
SCALE 3X, 4 PL

SECTION CJ-CJ
SCALE 3X, 4 PL

DETAIL AS
SCALE 2X

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

WELDING INSTRUCTIONS

1) CHAMFER HOLE 0.050 X 45°
2) INSERT D4170-1 SPACER
3) WELD INTO PLACE AND GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.313 X 0.50^{+0.08}/_{-0.00} DEEP

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4168	SHEET 10 OF 11
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

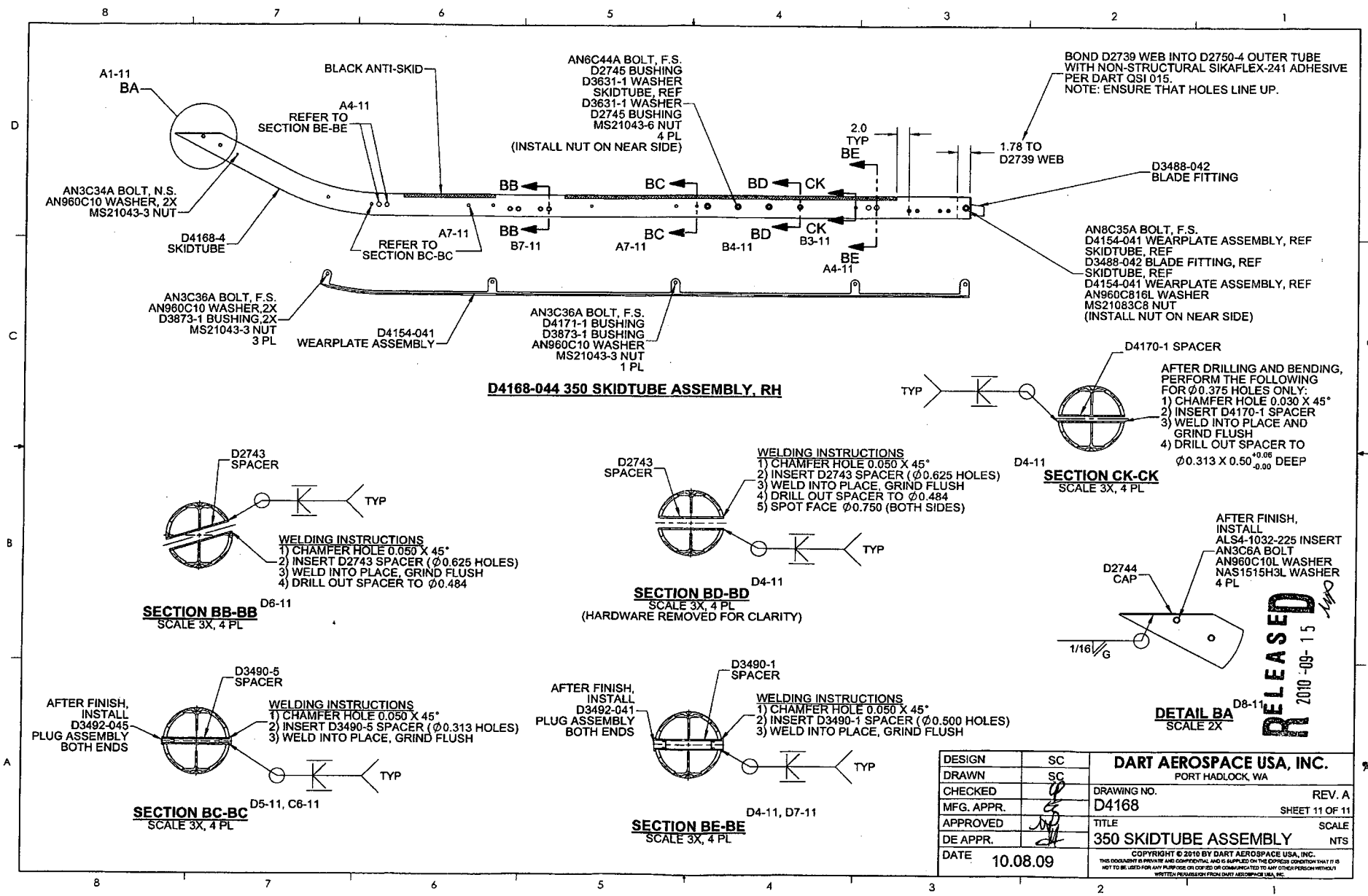
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76335



DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4168	SHEET 11 OF 11
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8.0 PARTS LIST

(D350-636-015/-016/-017/-018/-047 KITS)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
	X					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
		X				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
			X			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
				X		D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
					X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1					D4168-041	SKIDTUBE ASSEMBLY, LH
1		1				D4168-042	SKIDTUBE ASSEMBLY, RH
1			1			D4168-043	SKIDTUBE ASSEMBLY, LH
1				1		D4168-044	SKIDTUBE ASSEMBLY, RH
*1	1					D4168-1	SKIDTUBE WELDMENT, LH
*1		1				D4168-2	SKIDTUBE WELDMENT, RH
*1			1			D4168-3	SKIDTUBE WELDMENT, LH
*1				1		D4168-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER (OR NAS1149CO832R)
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149CO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER (OR NAS1149CO332R)
*20B	4	4	4	4		NAS1515H3L	WASHER
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1	1	AN3C42A	BOLT ³
*92	7	7	7	7	8	AN960C10	WASHER (OR NAS1149CO363R)
92A			1	1		AN960C10	WASHER (OR NAS1149CO363R) ³
*93	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	8	D3873-1	BUSHING
94A			1	1		D3873-1	BUSHING ³
*95	1	1	1	1	1	D4171-1	BUSHING ⁴
96					4	D4170-3	SPACER
*97	1	1	1	1	1	AN3C34A	BOLT ¹
*98	2	2	2	2	2	AN960C10	WASHER (OR NAS1149CO363R)
*99	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: I

Date: 10.10.25

NO. 276

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 75349
Part number: 350-636-01L
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Ford Date of Test Coupon 11.11.22
Welder Barclay Elliot Date of Test Coupon 11.11.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld